

3054.1625

Ship NOV 29

Work Order ID 153194

153194

Page 1

Wednesday, November 09, 2016 12:51:06 P

Item ID: 647.8511

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Insert

Start Date: 11/10/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/18/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

VS

Date: 11/11/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.8500

N/C

N/C

11/6-11-09

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.23

Doosan Lathe

1-Turn as per Folio FA596 Rev: N/A & Dwg 647.8500
Rev: N/C

2-Deburr

89

φ

11/6-11-19

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.03

Quality Control

89

φ

11/6-11-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID 153194

Wednesday, November 09, 2016 12:51:06 P

153194

Page 3

Item ID: 647.8511

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Insert

Start Date: 11/10/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/18/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

124

QC3- Inspect Part Finish

0.00

124

QC

Memo

0.00

Quality Control

9

DAS

38

9-89

DEC 12 2016

130

Identify as per dwg & Stock Location: ~~STOCK~~ *cc k 11/16*

0.00

130

Packaging

Memo

0.13

Packaging

LOCATION: WA001

9

DAS

6

9-89

DEC 12 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

DAS

21

9-89

DEC 14 2016

VS 16/12/13

DAS

21

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, November 09, 2016 12:51:15 PM

Page 1

Work Order ID: 153194

153194

Parent Item: 647.8511

647 8511

Parent Item Name: Insert

Start Date: 11/10/2016

Required Date: 11/18/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 16-11-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased	No				f	11.4210		0.355556			

M303R0 625

303 Round Bar 0.625"

16-11-19

Location

Loc Qty

Loc Code

MAT

11.421

m134213

0.431

m135463

10.99

431

27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

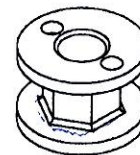
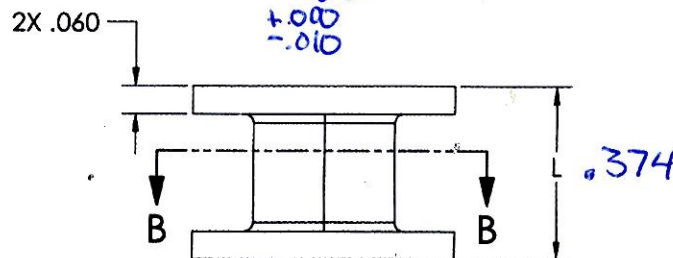
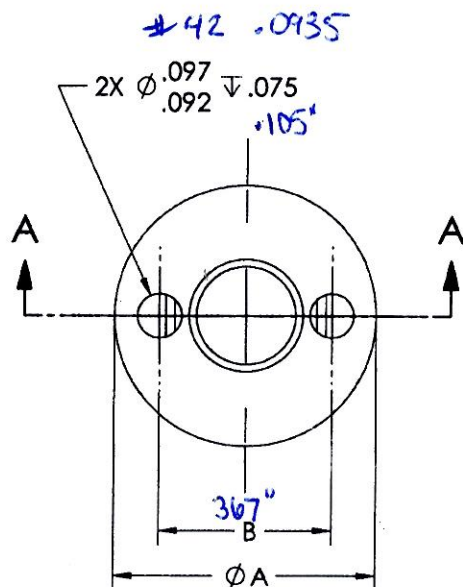
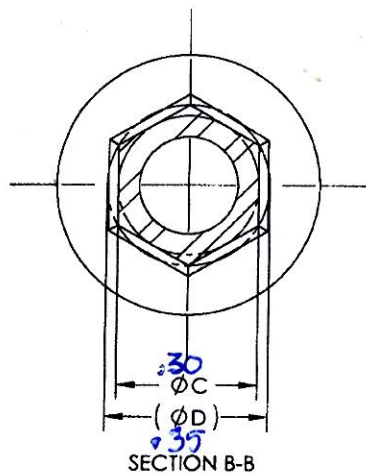
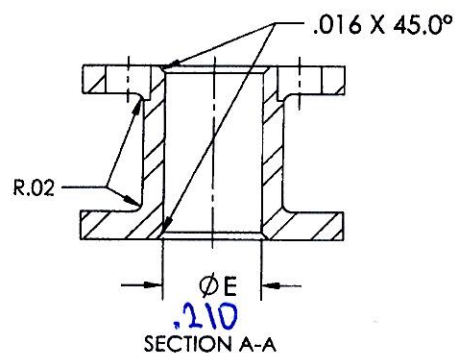
Work Order update only ☐

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OTHER :																					

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NOTES:

1. MATERIAL: 303 SERIES STAINLESS STEEL IAW AMS-5640 TYPE I
2. FINISH: PASSIVATE PER MIL-S-5002 TYPE 6
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.8510
647.8511 SHOWN
647.8512

PART #	SIZE	ØA +.000 -.010	B	ØC	ØD	ØE	L
647.8510	3	.560	.367	.30	.35	.210	.283
647.8511	3	.560	.367	.30	.35	.210	.374
647.8512	5	.685	.487	.41	.48	.322	.283

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15374

*W/C
02
14/1/9*

NEXT ASSY (S)		ORIGINAL DATE (MM-DD-YY) 01/13/10		APICAL INDUSTRIES	
DRAWN BY		CHECKED		2608 TEMPLE HEIGHTS DR.	
DESIGNED BY		DESIGNED BY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESIGNED BY		DESIGNED BY		INSERT	
CONTRACT NO.		CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01" 3 PLACE DECIMALS ±.005" ANGLES ±.5°		SHEET 07M26		DWG. NO. 647.8500	
		SCALE NONE		SHEET 1 OF 1	



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.:(514)335-3666 Fax.:(514)335-3868
Internet : www.groupaltech.com

**Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance**

Bon-Livraison / Pk.Slip # : 123295-1 06/12/2016
Bon-Commande. / W.Order # : 123295
Client P.O. # : PO33948
Transport : 74385 C216112/12

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	<u>No. Job</u> <u>No. Réf</u>	<u>NoSerie / Part Number</u> <u>Nom Produit / Product</u>	<u>Traitement</u> <u>Process</u>	<u>Poids</u> <u>Weight</u>	<u>Qté</u> <u>Qty</u>	<u>Envoyé</u> <u>Sent</u>	<u>A venir</u> <u>BO</u>
1	UNIT	647.8511 Rev.	PASSIVATION PER QQ-P-35	0.00	9	9	0

DEC 12 2016

DAS
38
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
Our financial and legal responsibility will not be higher than the amount of invoice.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34385**

Purchase Order Date 11/21/2016

PO Print Date 11/24/2016

Page Number 1 of 2

Order From :

GROUP ALTECH
2455 HALPERN

VC-ALT01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

ST LAURENT, MONTREAL H4S 1N9

Contact Name

Vendor Phone 514-335-3666

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FOB Origin

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extende Pric
1	153194	647.8511 INSERT	11/28/2016 Yes 11/28/2016		9.00	\$11.11	\$100.0
	FINISH: PASSIVATE PER MIL-S-5002 TYPE 6						
						Line Total:	\$100.0
2	71401-45	PROCUREMENT QUALITY CLAUSES	11/28/2016 No 11/28/2016		1.00	\$0.00	\$0.0
	Procurement Quality Clauses A004 FAA-PMA /TSO A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A024 PROCESS CERTIFICATIONS A025 CERTIFICATE OF CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS						

DEC 12 2016

SP

DART
6
5-11

Note:

JAS
38
1-89

11/24/2016